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D3913-041
Job Sheet 206488



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/20

Job Tracking No:

Due Date: 3/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV:C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/10/20		0.00	19.61	Large Fab - 1		K.S./CC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	3/10/20		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1	3/10/20		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Container No: S256117



Part: D3913-041

Job No: 206488

Serial No/Batch: S256117

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/14/20

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	3/10/20	0.00	0.29	Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	20-02-25
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White GI(S)-B4B	1 pcs	3/10/20	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	BEB 20-02-25
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	3/10/20	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	20-2-25
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	3/10/20	0.00	0.50	Handfinish - 4 - 1 - B4B	20-2-25
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 -	

DAS
34
9-89DAS
15
9-89

				B4B		
				Handfinish - 4 - 4 - B4B		
				Handfinish - 4 - 5 - B4B		
				Handfinish - 4 - 6 - B4B		
				Handfinish - 4 - 7 - B4B		
				Handfinish - 4 - 8 - B4B		
				Handfinish - 4 - 9 - B4B		
160	QC 5	1 pcs	3/10/20	0.00	0.00	QC 5 - 10
						QC 5 - 12
						QC 5 - 17
						QC 5 - 18
						QC 5 - 19
						QC 5 - 22
						QC 5 - 24
						QC 5 - 3
						QC 5 - 43
						QC 5 - 49
						QC 5 - 51
						QC 5 - 58
						QC 5 - 68
						QC 5 - 9
						QC 5 - 50
						QC 5 - 30
						QC 5 - 40
						QC 5 - 61
						QC 5 - 81
170	Packaging 3-1 - Stock - B4B	1 pcs	3/10/20	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B

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20-2-22

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	1 pcs	3/10/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: M139023 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder

coat START: 1:15 TEMP: 375 FINISH: 1:30

140 - QC3- Inspect Part Finish

150 - Assemble as per dwg - Pick Kit

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S246180
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S252319
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S230185
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S237362
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S242373
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S252343
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S246311
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S249540
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S242895
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S248314
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S243715
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S245036
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	2XS 242694 / 1XS 253605
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S240039
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S248308
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S236536
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S236300
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S249345
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S216911
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S243987
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S241500
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S136369

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	60	0
	D3913-1	1	12	0
	D3913-15	1	15	0
	D3913-3	1	12	0
	D3913-7	2	22	0
	D3913-9	1	13	0
	D3916-041	2	4	0
	D3916-5	3	11	0
	D4016-1	3	6	0
	D4017-7	3	96	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	8	0
	D4034-041	1	6	0
	D4034-043	1	3	0
	D4672-1	2	8	0
	M304EX0.75-16F	32	755	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	250	0
	D2931	2	519	0
	D4021-5	2	39	0
	MS20600-AD4W3	2	770	0
	MS21042L3	6	3,081	0
	NAS1149F0332P	12	5,458	0
	NAS1149FN832P	2	6,042	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐
					Quality ☐
Date: _____		Sequence #: _____		QTY Affected: _____	
Description Work Order Deviation		Disposition			
		MRB (QS1042)			
		Completed By			
		Lead hand / Supervisor			
QC / QA Coordinator					
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				